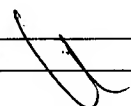













Date: Monday, 27/08/2007 2:53:57 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: DISASSEMBLE
Job Number	: 34267		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D3562042
This Issue	: 27/08/2007 S.O. No. :	Drawing Number	: D412-630-034
Prsht Rev.	: NC	Project Number	:
First Issue	: 27/08/2007 Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 34266	Material	:
Written By	: 	Due Date	: 03/09/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product	

Job Number:	
-------------	---

Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
		
	Comment: PACKAGING RESOURCE #1	
	REMOVE FROM STK:	
	1 X D412-630-033 B <i>32716</i> <i>u 07-08-27</i>	
2.0	D412630034	HELI ACCESS STEP, LH FOLDING
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)	
	HELI ACCESS STEP, LH FOLDING	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	DISASSEMBLE D2803/D2804 BRACKET ASS'YS	
	B <i>MF 07-08-27</i>	
4.0	QC5	INSPECT WORK TO CURRENT STEP
		
	Comment: INSPECT WORK TO CURRENT STEP <i>27-08-27</i> <i>①</i>	
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		
	Comment: PACKAGING RESOURCE #1	
	REPACKAGE AS ~ D3562-041 ~	
	RESTOCK PARTS <i>27/08/08</i> <i>①</i>	

Date: Monday, 27/08/2007 2:53:57 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 -Dart Aerospace Ltd.

Drawing Name: DISASSEMBLE

Job Number: 34267

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

*see 32716
for parts to return to stock*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

REPLACEMENT STEP WELDMENT FOR B/N 27271

ISSUE RED DECAL - D412-630-033 B34267

NEW PAPERWORK REQ'D

U 27.08.27

Job Completion



QC 21 final inspection w/o release

U 27.08.28

Date: Thursday, 5/31/2007 7:23:02 AM
 User: Kim Johnston

Adj DISASS D412630 28/08

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP RH (FOLDING)
 Job Number : 32716
 Estimate Number : 12568
 P.O. Number : *N/A* Part Number : D412630034
 This Issue : 5/31/2007 S.O. No. : *N/A* Drawing Number : IIN D412-630 REV K
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : K
 Previous Run : 32714 Material : *N/A*
 Written By : *JA* Due Date : 6/30/2007 Qty: *5* Um: Each
 Checked & Approved By : *JA 07.05.31*
 Comment : Est. Rev A New Issue 06-11-08 JLM

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG002

KS 07.06.05

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

*32551**14**SD*

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

*27283**26564**27392*

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

*27409, 27284**25920**7/7/11 SD*

Date: Thursday, 5/31/2007 7:23:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2807	Support Prop
-----	-------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

1529828 (2)

SD

6.0	D2813	Washer
-----	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

1529396 (2)

SD

7.0	D3562042	STEP ASSEMBLY, RH
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-042	Step Weldment RH

Batch

B32721

8.0	D33951	Bushing
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

1528455 (5)

SD
4 *
26770

KOX
32783

9.0	AN3C21A	BOLT
-----	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

1101189, 7/7/1159

Date: Thursday, 5/31/2007 7:23:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty Part Number Description
2 AN8C16 Bolt

Batch

M102736, ② SD

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty Part Number Description
2 AN310C8 Nut

Batch

⑨ ② SD ③
M102728, M104679

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Cotter Pin

Pick:

Qty Part Number Description
2 MS24665-302 Cotter Pin (or AN380C3-4)

Batch

M16941, SD

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer

Pick:

Qty Part Number Description
6 NAS1515H3 Washer

Batch

M102993, SD

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Pick:

Qty Part Number Description
4 NAS1515H5L Washer

Batch

M104679, 7/7/11 SD

Date: Thursday, 5/31/2007 7:23:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M102067

SD

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M104679

SD

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

7/2/11 SG

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M17045

MF 07-07-18

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

57/07/18 X5

Date: Thursday, 5/31/2007 7:23:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

42 ✓ 2 ✓ 64 ✓
B27285 ✓ 26565 29393 ✓

22.0 D28063 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-3	Bushing

Batch

2 ✓ 2 ✓ 4 ✓
E26162 ✓ 27286 28163 ✓ B29394 ✓

23.0 D28105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description
1	D2810-5	Strut

Batch

2 ✓ 1 ✓ 1 ✓
B27103 ✓ B27287 ✓ B29395 ✓

24.0 D33961 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description
2	D3396-1	Spacer

Batch

2 ✓ 2 ✓
B27287 ✓ B27290 ✓

25.0 AN4C6A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch

Batch

1 ✓
M104936 ✓
7/1/23 SP ✓

Date: Thursday, 5/31/2007 7:23:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	AN4C6A	Bolt
---	--------	------

26.0	AN4C10A	Bolt
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C10A	Bolt

Batch

1100273 ✓

SD

27.0	AN4C15A	Bolt
------	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN4C15A	Bolt

Batch

1102959 ✓

SD

28.0	AN44C7A	Eyebolt
------	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN44-C7A	Eyebolt

Batch

1101711 ✓

SD

29.0	AN5C15A	Bolt
------	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN5C15A	Bolt

Batch

1100229 ✓

SD

4

1101290 ✓

30.0	NAS1515H4	Washer
------	-----------	--------



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
* 7	NAS1515H4	Washer

Batch

1101428 ✓

7/7/23 SD ✓

Date: Thursday, 5/31/2007 7:23:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description
7 NAS1515H5 Washer

Batch

1104885 ✓

SD ✓

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description
4 MS21043-4 Nut

Batch

1104936 ✓

SD ✓

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description
3 MS21043-5 Nut

Batch

1104418 ✓

SD ✓

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/7/23 SD (5)

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

7/7/23 (5) EF 7/7/23 (5)

36.0 QC21 FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

7/7/23

Job Completion



7/7/23